

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027191**Date Inspected:** 21-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** Wai Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

**Bay Number 1**

FCAW welding of fillet welds located on Barrier Rails components identified as E5-SB1-023 weld number(s) 006~031. Welder is identified as welder no. 045221. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2132-3 & WPS-B-T-2133.

FCAW welding of fillet welds located on Barrier Rails components identified as E5-SB1-040 weld number(s) 006~031. Welder is identified as welder no. 201853. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2132-3 & WPS-B-T-2133.

**Bay Number 2**

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3343-001 weld number(s) 099. Welder is identified as welder no. 068554. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

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FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3343-001 weld number(s) 103. Welder is identified as welder no. 066236. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3343-001 weld number(s) 272. Welder is identified as welder no. 045276. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3343-001 weld number(s) 021. Welder is identified as welder no. 067877. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3343-001 weld number(s) 027. Welder is identified as welder no. 045280. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

### Bay Number 3

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel, by the lot method testing procedure. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 07055. The member(s) is/are identified as OBG Floor Beams. The weld designations reviewed are as follows:

1. FB3274-001-005~026, 035~049, 052, 055, 058, 059, 062, 063, 064, 065, 068~083.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 107 & 099. Welder is identified as welder no. 658859. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 243 & 178. Welder is identified as welder no. 070140. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 101 & 109. Welder is identified as welder no. 066695. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 125 & 280. Welder is identified as welder no. 068917. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

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FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 091 & 215. Welder is identified as welder no. 052696. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s)  
WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 031 & 023. Welder is identified as welder no. 050240. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s)  
WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 226 & 261. Welder is identified as welder no. 044830. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s)  
WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 033 & 025. Welder is identified as welder no. 055491. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s)  
WPS-B-T-2233-TC-U5-F.

SAW welding of complete joint penetration weld joint(s) located on lift 14 OBG sub assembly identified as SA3338-001 weld number(s) 040 & 001. Welder is identified as welder no. 207288. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s)  
WPS-B-T-2221-B-126-S-2.

Bay Number 4

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. All components were as listed on NWIT notification no.(s) 07046. The member(s) is/are identified as OBG Side Anchorage assembly. The weld designations reviewed are as follows:

1. SA3359-001-001
2. SA3363-001-001

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

### Summary of Conversations:

Pertinent conversations are included in the body of the report.

### Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez,Rene	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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